

5/42

DART AEROSPACE LTD	Work Order:	24374
Description: Plug	Part Number:	D2594-1
Dwg: D2594 Rev. B1	Qty:	500 513
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	RF	05.09.29	500
2	MC	Make as per Dwg D2594-1 and Folio FA262. Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8) 1100-0 (QQ-A-225/1) Ø0.625" Rod (M5052H32R0.625) or (M6061T6R0.625) <i>M18740</i> Batch <i>M18314</i>	<i>RF</i>	<i>05/11/03</i>	<i>513</i>
3	MC	Break all sharp edges 0.010 max.	<i>SAD</i>	<i>06/11/03</i>	<i>513</i>
4 A	QC2	Inspect dimensions as per drawing D2594	<i>RF</i>	<i>05/11/03</i>	<i>513</i>
4 B	QC8	Second check	<i>S.G</i>	<i>05/11/14</i>	
5	FP	Acid etch and alodine as per QSI 005 4.1	<i>SAD</i>	<i>05/11/20</i>	<i>513</i>
6	FP	Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)	<i>FC</i>	<i>05/11/23</i>	<i>513</i>
7	QC3	Inspect Powder Coat	<i>MM</i>	<i>05/11/24</i>	<i>513</i>
8	FP	Identify and Stock	<i>MM</i>	<i>05/11/24</i>	<i>513</i>
9	AC	Cost / part	<i>Sur</i>	<i>05-11-25</i>	<i>513</i>
10	DC	Close W/O Inspect Level 21	<i>RF</i>	<i>05/11/25</i>	<i>513</i>

Rev	Date	Change	Revised By	Approved
A	98.11.27	New Issue	DM	
B	00.11.01	Removed P/O for Powder Coat – in house process	EC	
C	01.07.17	Reformat step 2	SM	
D	02.08.22	Make in Cobra	KJ RF	<i>RF</i>

RELEASED
02/08/22 RF

RF
02/10/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 05/11/25

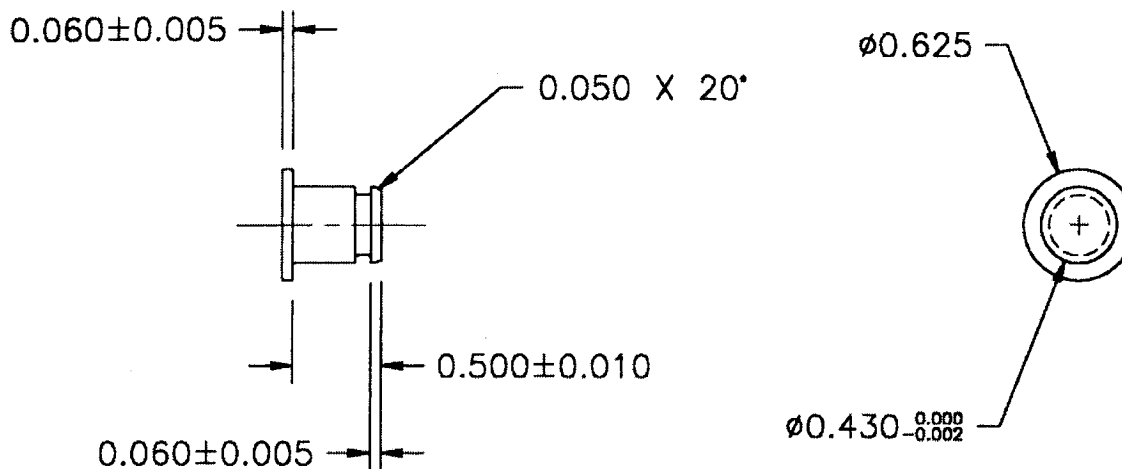
NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



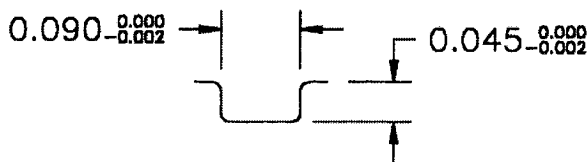
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2594	REV. B SHEET 1 OF 1
DATE 96:09:16		TITLE PLUG	SCALE 1:1
B	97:03:15	ADD GROOVE AND O-RING	
B1	RF 02.08.26	ADD POWDER COAT, QSE 018, & QQ-A SPECS.	

D2594-1 PLUG:

RELEASED
97/03/27 DS



GROOVE DETAIL (SCALE 5:1)



TOLERANCES ARE PER DART QSE 018 UNLESS OTHERWISE NOTED.

BREAK ALL SHARP CORNERS 0.010 MAX

MATERIAL: 5052-H32 OR 6061-T6 OR 1100-0

FINISH: ACID ETCH, ALODINE

POWDER COAT WHITE (REF. 43.S.1) PER QSE 005 4.3

PER QQ-A-225/7 (5052)
OR QQ-A-225/8 (6061)
OR QQ-A-225/1 (1100)
OR QQ-A-200/8 (6061)

SHOP COPY

RETURN TO
ENGINEERING

D2594-3 O-RING: 5/16 ID, 7/16 OD, 1/16 WIDTH (PARKER 2-011)

D2594 PLUG ASSEMBLY INCLUDES:

- (1) D2594-1 PLUG
- (1) D2594-3 O-RING

WITH ORDER

24374

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 28, 2005
03:40 pm

Work Order No : 0024374
Project Name : D2594-1
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D2594-1
Description : Plug
Manufactured : Yes
Amount Req'd : 500
Amount Done : 0
Start Date : 09-28-05
Est Finish Date : 10-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00